Elus

98160

Page

Name Date Date Date Date Date Date SPC (Y/N): Date D	' *NS2*
Start Date: 3/08/13 Start Qty: 12.00 *12 *12 * Cust Item ID: Required Date: 3/29/13 Req'd Qty: 12.00 *12 *12 * Customer: Reference: Approvals: Process Plan: Date: 3/28/25 Tooling: Date: Start Qty: 12.00 *12 *12 * Customer:	י *NR1*
Required Date: 3/29/13 Req'd Qty: 12.00 *12.	"NR1"
Reference: Approvals: Process Plan: Date: Star OC: Star	"NR1"
Stor	"NR1"
QC: Date: SPC (Y/N): Date:	, **IDV†
Date.	"NK7^
Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Work Center ID Description Run Hours Code Qty Qty	Reject Insp. Number Stamp
Draw Nbr Revision Nbr	
D2933 Rev C	
100 *100 *100 HAAS CNC VERTICAL MACHINING #1 HAAS 1 Memo 0.00 FK_ 13/04/23 12 0.00	
HAAS CNC vertical machine #1 Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per	
0.00	
110 CONVENTIONAL MILLING MACHINE	
Mill Conv Conventional Milling Machine Memo 0.00 Machine Keyway and inspect per attached dimension sheet I.K. 13/04/23	
120 QC1- Inspect dimensions to dimension sheet 0.00	
120 QC Quality Control Memo 0.00	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	D	ate:	-	`	
J 4,					 ,

	,							•		QA Closed:	Date:		
Work Orde	r•		,		DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No. Rework Scrap Use-as-is				- - - - 1 .	ſ	Skid-tube Machining	Crosstube Small Fab Finishing	⊣	Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other			
NCR N								Large Fab	Composite	<u></u>	Supplier		
Root	:			Descr	iption of work order update	lni	tial	Ac	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator					**								
Material					•		-						
Setup			ļ										
Other													
Process				ļ.	•								
Supplier					Ì		•		}				
Training		,		ļ									
Unapproved													
					F	AULT	CATE	GORY					
Landin	g Gear				General					~	<u></u>	¬	
· [Bending				Bend	\square G	irain		_	Ovalized	· L	Pressure/Forced	
L	Centre No	ot Conce	ntric to	o/s	BOM/Route	Н	ardwa	re		Over/Under		Temperature/Cure	
_	Cracks	•			Broken/Damaged	-		ion Incomplete	<u> </u> _	Part Incorre		Weld	
	Crushed/0	Crimped			Burrs ,			ions Incomplete	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs Contamination						enance	· <u> </u>	Part Moved				
	Heat Treat Countersink				\vdash	1islabe		<u> </u>	Positioned V	_	7		
	Inspection		Tube	<u> </u> _	Cut Too Short	\vdash	1isreac	d		Power Loss/	Surge	Other	
Ripples in Bend Drill Holes						\vdash	ffset						
Torque Waves in Extrusion Drawing						Out of Calibration							
	Turning Sequence Finish						Out of Sequence						
	Wave/Twist in Tube Folio						utside	Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

March-08-13 9:52:36 AM Item ID: D2933-2 Accept *N900040100* Setup Start **Revision ID:** Item Name: Saddle RH In. 206 **Start Date:** 3/08/13 **Start Oty: 12.00** Cust Item ID: Required Date: 3/29/13 Req'd Oty: 12.00 **Customer:** Reference: Run Approvals: Process Plan: ____ Date: ____ Tooling: Date: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description Run Hours Code Qty Otv Number Stamp 130 QC8- Inspect parts - second check 0.00 *130* OC 0.00 Memo Quality Control 140 Chemical Conversion Coat per QSI005 4.1 0.00 *140* 12 76/3425 HandFinish 0.00 Memo Hand Finishing 155 Spray Painting per QSI005 4.2 0.00 *155* 12 SprayPaint 0.00 Memo Spray Painting PRIME B /25/52 DELFLEET BLUE B 123 253
DELFLEET CLEAR B/25 035 START TIME: チルロ

FINISH TIME: 4:30

NCR: Yes / No	WORK ORDER NON-CON	WORK ORDER NON-CONFORMANCE / UPDATE							
		QA Closed:							
Work Order:	DISPOSITION	AGAINST DEPARTMENT,							
Work order.	Rework	Skid-tube Crosstube							
Part No.	Scrap	Machining Small Fab Pro							

Work Order Update

Description of work order update

or Non-conformance

General

Bend

BOM/Route

Broken/Damaged

Use-as-is

Thermoforming

Initial

Chief Eng

Large Fab

Action

Description

			΄ κ΄	
	DQA:	Da ⁻	te:	_
ATE	QA Closed:	Da	ite:	٠,
AGAINST DE	· *** · : ********** :)	/PROCESS		1
Crosstube Small Fab Finishing Composite	Pro	Water Jet d. Eng. Coor. re/Packaging Supplier	Quality Other	
on otion	Sign & Date	Verificatio	n QC Inspector	
				\dashv
nclear	Ovalized Over/Under Part Incorred Part Lost/M Part Moved Positioned V Power Loss/	ct issing ··· Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
				\dashv

Wrong Stock Pulled
Other
Oth

FAULT CATEGORY

Grain

Hardware

Inspection Incomplete

Part No.

NCR No.

Landing Gear

Bending

Cracks

Step

Centre Not Concentric to O/S

Date

Qty

Root

Cause

Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved

Insp.

March-08-13 9:52:36 AM Item ID: D2933-2 Accept *N900040100* Setup Start **Revision ID:** Saddle RH In. 206 Item Name: **Start Date:** 3/08/13 **Start Qty: 12.00 Cust Item ID:** Required Date: 3/29/13 Req'd Qty: 12.00 **Customer:** Reference: Run Process Plan: **Approvals:** Date: _____. Tooling: Date: Date: SPC (Y/N): Date: Sequence ID/ **Operation** Set Up/ Tool ID Tool # Plan Reject Reject Accept **Work Center ID** Description **Run Hours** Qty Number Stamp Code Qty 165 QC14- Inspect Spray Paint 0.00 *165* Memo 0.00 Quality Control Identify as per dwg & Stock Location: \$\int 425A 170 *170* Packaging Memo 0.00 Packaging 180 QC21- Final Inspection - Work Order Release 0.00 *180* 0.00 Memo Quality Control

											DQA	Dat	e:	
NCR:	Yes / No					WORK ORDER NON-CONFORMANCE / UPDATE							•	
								O P. Zacelan C. E		QA Closed	: Dat	:e:		
Work Orde	Mark Order				DISPOSITION AGAINST DE			AGAINST DE	PARTMENT/PROCESS					
VVOIR OTAR	Ξ1.		· · · · · · · · · · · · · · · · · · ·		·	Rework	1		Skid-tube	Crosstube]	Water Jet		Engineering
Part N	No.					Scrap		l .	Machining	Small Fab	Pro	od. Eng. Coor.		Quality
						Use-as-is]	Thern	noforming	Finishing	Rec/Sto	re/Packaging		Other
NCR 1	٧o.					Work Order Update			Large Fab	Composite		Supplier		
					Danasi	ation of work order undete		nitial	Actio	n	Sign &	<u> </u>		TO STATE OF THE ST
Root		Date	Step	Qty		ption of work order update or Non-conformance	1	nief Eng	Descrip		Date	Verification	1	QC Inspector
Cause Doc/Data	Γ-	Date	step	Qty		or Non-comormance		ilei Liig	Везспр		Date	Vermedia	•	QC 1115pector
Equip/Tooling														
Operator	-													
Material			•											
Setup			ļ											
Other							ļ							
Process														
Supplier														
Training			ļ											
Unapproved		<u> </u>	l									<u> 1 </u>		
							AUL	T CATE	GORY					
Landi	ng-(1				General		Grain			Ovalized	+		Pressure/Forced
İ	_	Bending Centre No	-+ C		~/s	Bend BOM/Route	-	Hardwa	ro	-	Over/Unde	r tolerance	-	Temperature/Cure
	┝	Cracks	ot Concer	itric to	^{3/3} -	Broken/Damaged	\vdash	┥	on Incomplete	<u> </u>	Part Incorre		 	Weld
	\vdash	Crushed/	Crimned		-	Burrs	\vdash	4 .	ions Incomplete/Un	clear	Part Lost/N		\vdash	Wrong Stock Pulled
	\vdash	Cuffs	ci iiipeu,		-	Contamination	-	Mainte	•	Credi	Part Move	=	L	121.8 2122 41164
		Heat Trea	t		-	Countersink		Mislabeled			Positioned			
	Inspection Strip in Tube Countersink Cut Too Short				╡		Misread			Power Loss	_		Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

Picklist Print

March-08-13 9:52:42 AM

Work Order ID: 98160

98160

Parent Item:

D2933-2

D2933-2

Parent Item Name: Saddle RH In. 206

Start Date: 3/08/13

Required Date: 3/29/13

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP: B00.06.26New DWG rev (mpp 2069)EC IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	_	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date s	Status	
D6101-001		Manufactured	No			100	Each	2.0000	I	12			+	
D6101-00	1								**		PO	13/04/2	ـ	

Location Loc Oty Loc Code MAT042 2 94445 2

12

											DQA	\:D	ate:	· · · · · · · · · · · · · · · · · · ·
NCR:	Yes	/ No				WORK ORDER NON-C	O	VFORM	MANCE / UP	DATE				
		,									QA Closed	d: Da	ate:	
Work Orde	er:					DISPOSITION			•	AGAINST DI	PARTMEN	T/PROCESS		
Part No					Scrap Machining Sma Use-as-is Thermoforming Fini			Crosstube Small Fab Finishing Composite	Fab Prod. Eng. Coor. Qualining Rec/Store/Packaging Other					
Root	- 1				Descri	ption of work order update		Initial	Ac	tion	Sign &			
Cause		Date	Step	Qty	•	or Non-conformance	1	ief Eng		ription	Date	Verification	on	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		Ŷ							· · · · · -	• •				
						F	AUL	T CATE	GORY					
Landi						General Bend		Grain			Ovalized			Pressure/Forced
	-	Bending Centre No	nt Conce	ntric to	0/5	BOM/Route		Hardwa	re	ŀ		er tolerance		Temperature/Cure
	-	Cracks			- ' -	Broken/Damaged		4	ion Incomplete	-	Part Incori			Weld
	П	Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/	'Unclear	Part Lost/I	Missing		Wrong Stock Pulled
		Cuffs				Contamination	L	Mainte			Part Move			
	Ш	Heat Trea	it			Countersink		Mislabeled			Positioned			7
·	Ш	Inspection	ction Strip in Tube Cut Too Short					Misread			Power Los	s/Surge		Other
		Ripples in	Bend	<u> </u>										

Out of Calibration

Out of Sequence

Outside Dimensions

Drill Holes Drawing

Finish Folio

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	98/1/8
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
		/
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Re	corded Acti	ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	. 2	3	4	Ву	Date
Α	0.100	0.140		.125	125	-124	175		
В	0.100	0.140		.125	0125	.125	-124		
С	0.100	0.140		.170	.120	.120	.120		
D	0.210	0.230		. 720	. 219	, 218	350		
E	1.245	1.255		1.250	1.250	1,250	1,250		
F	1.245	1.255		1.250	1,250	1.250	1.250		*
G	2.495	2.505		2,500	2.500	2.5 ∞	2.500		
Н	0.510	0.515		,512	.512	512	+51Z	i i	
_1	1.572	1.582		1.577	1.577	1.577	1,577		
J	2.495	2.505		71.500	2,500	2.500	2.500		
K	0.257	0.262		.258	،25%	.258	0258		
L	0.312	0.317		.314	-314	.314	.314		
М	0.235	0.240		,233	. 238	. 238	.238		
N	0.100	0.140		-121	,120	119	0119		
0	0.540	0.560		₂ 551	. 551	-551	°551		
P	0.490	0.510		0500	& 500g	.500	-499		
Q	3.715	3.725		3,720	3.720	3.720	3,720		
R	2.470	2.510		2,492	2,492	2,492	2,492		
S	0.240	0.270		.251	,251	.251	.250		
T	0.100	0.180		.130	0130	a/30	6/30		
U	1.625	1.635		1.630	1,630	1.630	1.630		
٧	1.362	1.372		1,367	1,367	1.367	1.367		
W	0.316	0.321		-316	v316	e316	-316		
Х	1.125	1.145		1.1355	10136	18/345	1.135		
Υ	1.565	1.585	DT8695 A/B	1.5745	1.575	1.5735	1.574		
Z	0.178	0.198		./88	. 188	88/2	.188		
AA									
AB				4					
AC			•						
AD									
AE									
AF									
AG									
AH					T		77.		

Measured by:	F*	Audited by Audited
Date:	13/04/23	Date: 13/04/24

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	-1
С	07.03.21	Revised per drawing revision C	KJ/JLM ox	Sull

ART AEROSPACE LTD	Work Order:	98/1/8
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C	· · · · · · · · · · · · · · · · · · ·	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

A 0.100 0.140 .125 .					Recorded Actual Dimensions					
A 0.100 0.140 B 0.100 0.140 C 0.100 0.140 C 0.100 0.140 D 0.210 0.230 E 1.25 1.25 1.25 1.25 1.25 1.25 1.25 1.25	Dim	Min	Max		5	1 a	9	S .	Ву	Date
B 0.100 0.140		0.100	0.140		125	.125	- 125		† · · · · · · ·	
C 0.100 0.140 .120 .120 .120 .120 .220		0.100	0.140			.124				
D 0.210 0.230		0.100	0.140							
E 1.245 1.255		0.210	0.230							
F 1.245 1.255		1.245	1.255						<u> </u>	
G 2.495 2.505										
H 0.510 0.515			2.505		2,500			+		
1.572 1.582 1.577 1.575 1.57	Н		0.515							
J 2.495 2.505 2.500 2.500 2.500 2.500 2.500	J	1.572	1.582							
K 0.257 0.262 258 258 258 258 258 L 0.312 0.317 314 314 314 314 314 M 0.235 0.240 238 238 238 238 N 0.100 0.140 122 120 O 0.540 0.560 551 552 551 P 0.490 0.510 550 552 551 P 0.490 0.510 550 560 560 560 Q 3.715 3.725 3.720 3.720 3.720 3.720 3.720 3.720 2.492 2.492 2.492 2.492 2.492 2.492 2.492 2.492 2.492 2.492 2.492 3.720 1.720	J	2.495	42.505							
L 0.312 0.317	K	0.257	0.262					. 25%		
M 0.235 0.240 .238 .238 .238 .238 .238 N 0.100 0.140 .120 .119 .122 .120 O 0.540 0.560 .551 .552 .552 .551 P 0.490 0.510 .5CC .5CO .5CO .5CO .5CO Q 3.715 3.725 3.710 3.720 3.720 3.720 3.720 3.720 3.720 2.492 2.492 2.492 2.492 2.492 2.492 3.720 3.	L	0.312	0.317					-314		
N 0.100 0.140	М	0.235	0.240					,278		
O 0.540 0.560 .551 .552 .552 ,551 P 0.490 0.510 .5CC .5CC .5CC .5CC .5CC .5CC .5CC .5C	N	0.100	0.140							
P 0.490 0.510	. 0	0.540	0.560							-
Q 3.715 3.725 3.720 3.720 3.720 3.720 R 2.470 2.510 2.492 2.492 2.492 2.492 S 0.240 0.270 .251 ,250 .249 .250 T 0.100 0.180 .130 .130 .130 U 1.625 1.635 1.635 1.630 1.630 1.630 V 1.362 1.372 1.367 1.367 1.367 1.367 W 0.316 0.321 .316 .316 .316 .316 .316 X 1.125 1.145 1.145 1.134 1.355 1.136 1.136 Y 1.565 1.585 DT8695 A/B 1.573 1.5745 1.575 Z 0.178 0.198 .188 AA AB AB AC AA AB AA AB AA AB AA AB AA AB AA AA AB AA AA	Р	0.490	0.510						 	
R 2.470 2.510 2.492 2.492 2.492 2.492 S 0.240 0.270 .251 ,250 .249 .250 T 0.100 0.180 .130 .130 .130 .130 .130 U 1.625 1.635 1.635 1.630 1.630 1.630 1.630 V 1.362 1.372 1.367 1.367 1.367 1.367 W 0.316 0.321 .316 .316 .316 .316 .316 X 1.125 1.145 1.134 1.135 1.136 1.136 Y 1.565 1.585 DT8695 A/B 1.573 1.575 1.575 Z 0.178 0.198 .189 .189 .188 AA AB AB AC AA AB AB AC AA AB AA AB AA AB AA AB AA AB AA AA AB AA AA	Q :	3.715	3.725	10.0					 	
S 0.240 0.270		2.470	2.510						<u> </u>	
T 0.100 0.180 .i% .i% .i30 .i30 .i30 U 1.625 1.635 i.630 i.630 i.630 i.630 V 1.362 1.372 i.367 i.367 i.367 W 0.316 0.321 .316 .316 .316 X 1.125 1.145 i.134 i.1355 i.138 i.136 Y 1.565 1.585 DT8695 A/B 1.573 i.5745 i.575 Z 0.178 0.198 i.99 i.99 i.99 i.99 AA	S *	. 0.240	0.270						<u> </u>	
U 1.625 1.635	Τ,	0.100	0.180							
V 1.362 1.372 1.367 1.368 1.367 1.3		1.625	1.635							
W 0.316 0.321	V	1.362	1.372							
X 1.125 1.145 1.134 1.1355 1.138 1.136 Y 1.565 1.585 DT8695 A/B 1.5月3 1.5月5 1.5月5 1.5月5 2 0.178 0.198 1.198 1.198 1.198 1.198 AA AB AB AC AD AE AF AG AH	W	0.316	0.321					-3110		
Y 1.565 1.585 DT8695 A/B 1.573 1.5745 1.5745 1.5745 2 0.178 0.198 1.88 1.88 1.88 1.88 1.88 1.88 1.88		1.125	1.145							
Z 0.178 0.198 .189 .189 .188 .188 .188 .188 .188	Y	1.565	1.585	DT8695 A/B	1.573					
AA	Z	0.178	0.198							
AC	AA									
AD	AB						,			
AD	AC							· · · · · ·	/	
AF AG AH	AD									
AG AH	ΑĒ							<u> </u>		
AH AH	AF							<u> </u>		
	AG									
Accept/Reject	АН							<u> </u>		
		Acc	ept/Reje	ct						

Measured by:	Audited by
Date: Date: 1	
Date: 13/04/24	Date: 13/04/24

Rev	Date	Change	Revised by	Approved
Α		New issue	RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	1
С	07.03.21	Revised per drawing revision C	KJ/JLM OK	Sull

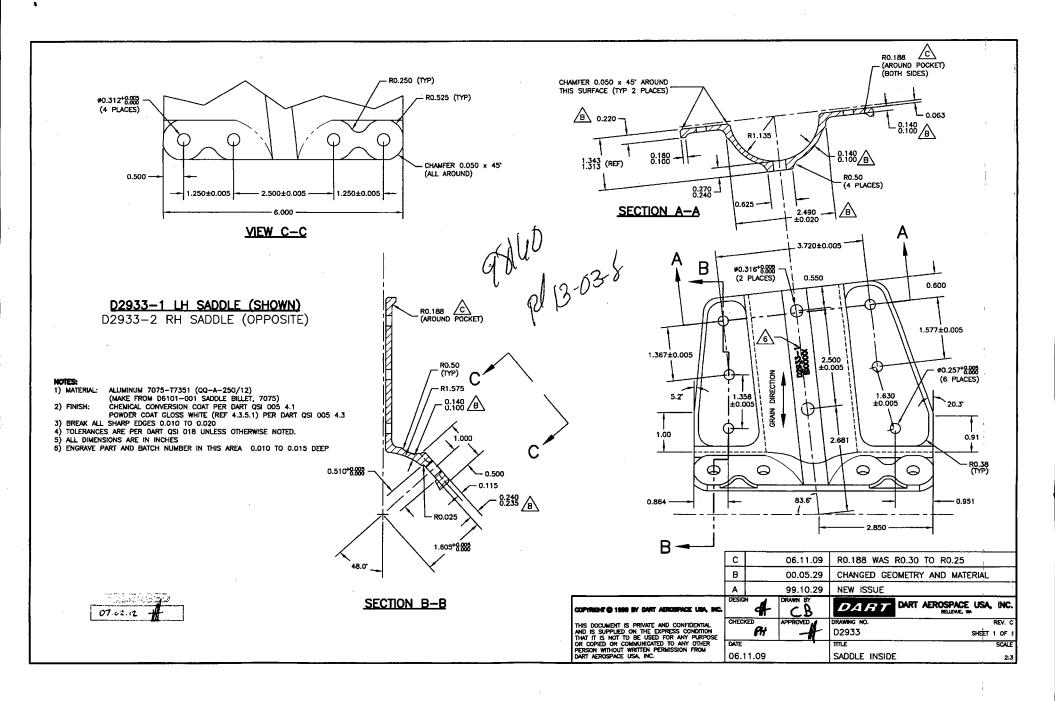
DART AEROSPACE LTD	Work Order:	981118
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Re	corded Act	ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	9	10	9	12	Ву	Date
Α	0.100	0.140		. 125	0. /23	,125	.125		
В	0.100	0.140		-125	.124	-125	./25		
С	0.100	0.140		,120	.120	+120	0/20		
D	0.210	0.230		-220	.219	.220	.220		
E	1.245	1.255		1,250	1,250	1,250	1,250		
F	1.245	1.255		1,250	1.250	1.250	1,250		
G	2.495	2.505		2.500	2,500	2,500	2,500		
Н	0.510	0.515	14	,512	.512	SIL	.5/2.		
ı	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2,500	2,500	2.500	2,500		
K	0.257	0.262	15	-528	,258	e 258	1258		
L	0.312	0.317		·314	.314	314	,314		
M	0.235	0.240		· 538	.238	.238	6238		
N	0.100	0.140		.120	0/19	. /20	0/19		
0	0.540	0.560		.551	-551	. 551	.551		
Р	0.490	0.510		,500	1500	,500	.500		•
Q.	3.715	3.725		3,720	3,720	3.720	3,720		
R:	2.470	2.510		2,492	2.492	2.492	2,492.		
s ·	. 0.240	0.270		. 251	\$550	.251	.251		
T	0.100	0.180		o 130	130	-130	.130		
U .	1.625	1.635		1,630	1.830	1.630	1.630		
V	1.362	1.372		1,367	1.367	1,367	1.367		
W	0.316	0.321		-316	.316	316	316		
Х	1.125	1.145		1.136	1,1355	1,1345	1.134		
Υ	1.565	1.585	DT8695 A/B	1.575	1.5745	1.5735	1.573	1	
Z	0.178	0.198		- 188	6188	0188	0/88		· · · · · · · · · · · · · · · · · · ·
AA					1	1			
AB									
AC									
AD									
AE							<u> </u>		
AF								4	
AG									
AH		,			``				
	Acc	ept/Reje	ct						

Measured by:	F.K.	Audited by	
		1.0.0.1.0.0.7	
Date:	12/81/74	Data	12/01/11
Date.	13/04/64	Date:	1.2/1)4/2/4
	7 7 7		

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	- 1
С	07.03.21	Revised per drawing revision C	KJ/JLM ox	Gul!



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